

Work Order ID 75348

75348

Page 1

October-21-11 8:03:27 AM

Item ID: D350-636-016 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube STD w/ Training Wearplates, RH
 Start Date: 20/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 02/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *R* Date: *11-10-20* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3492	C								
D4168	A								
IIN-D350-636	I								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-016 CHG 002

NA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Stop

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1

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Required Date: 02/11/2011 Req'd Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr, section R-R

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section R-R

5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per dwg D4168 Detail J

6- Drill pilot holes as per Dwg D4168 sheet 5 (D4168-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail K. ***SECOND SIDE***

8-Drill most FWD wearplate hole using DT9678 locating of 66.54" hole

9-Open up holes of Detail J to 0.297" (total of 2 holes per side) +.201 iplace per side and open holes of detail M section R-R to 0.500" as per dwg D4168

10-Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch:

M118735

BE 11-11-24

W/O:		WORK ORDER CHANGES					
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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Grind welds flush as per Dwg D4168

1 B 11/11/25

120 QC10- Inspect visual per QSI004- ground welds 0.00

120

QC

Memo

0.00

Quality Control

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

Quality Control

8 u/u/25

8 u/u/25

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00				①		36/11/26	
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

11-11-26

1 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00

160

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side)
as per dwg D4168.2-Open up holes of Detail K to 0.750" (total of 4 holes per side)
as per dwg D4168.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail K,L, ground handling and float holes per dwg D4168
(welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch:

exp. date:

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod

batch:

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D4168

10/11/26

119399 12/08/13

M118735 78611-12-04

11-12-5

W/O:		WORK ORDER CHANGES					
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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D4168

12- C'bore section CH-CH

13- Deburr holes

***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING
HOLE IN TUBE *****

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

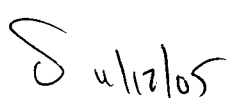
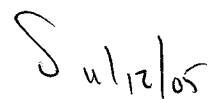
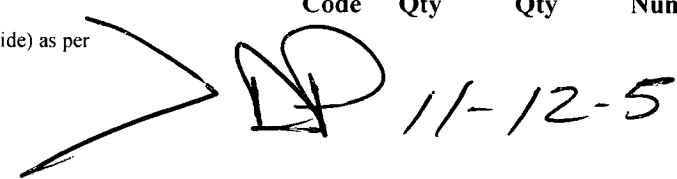
180

QC

Memo

0.00

Quality Control



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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 Pressure Wash per QSI005 4.3 0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1XØ M-L 11/12/10

200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

200

Powdercoat

Powder Coating

Memo

START TIME: *9:30*OVEN TEMPERATURE: *320 OF*FINISH TIME: *10:00*

0.00

1XØ M-L 11/12/12

210 QC3- Inspect Part Finish 0.00

210

QC

Memo

0.00

Quality Control

✓ Inspect for foreign object per QSI 024

1RH Ø M-L 11/12/27

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Item ID: D350-636-016

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Start Date: 20/10/2011 Start Qty: 1.00 ***1***

Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-636-016								
	Location: _____								
	PPP rev: _____								
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

11/12/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

October-21-11 8:03:32 AM

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Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC
11.04.14 ecn11-553 DD verf:EC
per NCR 11-906 DD verf:EC

IPP Rev:B
IPP Rev:C 11.10.18 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3490-1		Manufactured	No			160	Each	42.0000	4	4			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3490-1

Cross Bolt Spacer

**

BE11-12-04

B 74875 x 4

Location	Loc Qty	Loc Code
----------	---------	----------

LG	40	
----	----	--

67773	5	
-------	---	--

71841	35	
-------	----	--

LG001	2	
-------	---	--

62450	2	
-------	---	--

D3490-3		Manufactured	No			160	Each	42.0000	4	4			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3490-3

Cross Bolt Spacer

**

BE11-12-04

B 76234 x 4

Location	Loc Qty	Loc Code
----------	---------	----------

LG	42	
----	----	--

73295	42	
-------	----	--

AN3C34A		Purchased	No			230	Each	66.0000	1	1			
---------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

AN3C34A

BOLT

**

11/12/2011

Location	Loc Qty	Loc Code
----------	---------	----------

ST353	66	
-------	----	--

116075	42	
--------	----	--

117514	20	
--------	----	--

118838	4	
--------	---	--

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Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C36A

Purchased No

230

Each

156.0000

4

4

AN3C36A

BOLT

**

41 4/12/21

Location

Loc Qty

Loc Code

FG

14

101261

4

116590

10

ST353

142

116590

0

119083

12

119125

30

119324

100

44

AN3C37A

Purchased No

230

Each

139.0000

1

1

AN3C37A

BOLT

**

119531

Location

Loc Qty

Loc Code

ST354

139

116874

11

117010

2

118518

51

118709

50

119324

25

AN3C42A

Purchased No

230

Each

45.0000

1

AN3C42A

BOLT

**

11/12/22

Location

Loc Qty

Loc Code

ST354

45

106176

2

117763

20

118131

20

118451

3

W/O:		WORK ORDER CHANGES					
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Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-042 Manufactured No

230 Each 18.0000 1 1

D3488-042

Blade Fitting Assembly, RH

**

HL 11/12/21

Location

Loc Qty

Loc Code

FP008

18

62003

1

69904

6

71883

11

D3492-1 Manufactured No

230 Each 158.0000 8 8

D3492-1

Plug *D3492-041 **

**

B 70185 (x8) HL 11/12/21

Location

Loc Qty

Loc Code

FP

158

69531

8

73402

70

74444

80

D3492-3 Manufactured No

230 Each 117.0000 8 8

D3492-3

Plug *D3492-043 **

**

B 68508 (x8) HL 11/12/21

Location

Loc Qty

Loc Code

FP

117

71838

37

74447

80

D3873-1 Manufactured No

230 Each 356.0000 7 7

D3873-1

Bushing

**

B 76792 (x7) HL 11/12/21

Location

Loc Qty

Loc Code

ST088

356

64760

1

68247

4

73829

19

73831

332

W/O:		WORK ORDER CHANGES					
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Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4154-041

Manufactured No

230 Each

4.0000 1 1

D4154-041

Wearplate Assembly

**

B77664 (✓) 11/12/21

Location

Loc Qty

Loc Code

FP

4

71442

4

D4170-1

Manufactured No

230 Each

36.0000 4 4

D4170-1

Bushing

**

BE11-12-04
B76677 x2

Location

Loc Qty

Loc Code

LG

32

68225

1

71844

31

LG002

4

65912

4

D4171-1

Manufactured No

230 Each

10.0000 1 1

D4171-1

Bushing

**

11/12/21

Location

Loc Qty

Loc Code

ST135

10

69037

10

MS21043-3

Purchased No

230 Each

921.0000 4 4

MS21043-3

Nut

**

11/12/21

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

849

118077

1

118614

492

118686

356

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75348

75348

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0363R

Purchased

No

230

Each

3,939.000

9

NAS1149C0363R

Washer

**

9/7

11/12/20

Location

Loc Qty

Loc Code

ST297

3939

114742

3939

9/7

NAS1515H3L

Purchased

No

230

Each

111.0000

4

***NAS1515H3L ***

WASHER

**

4

11/19/20 (x4) 11/12/20

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

71

113362

57

118686

14

NAS1611-010

Purchased

No

230

Each

105.0000

8

NAS1611-010

O-RING

**

8

11/19/20 (x8) 11/12/20

Location

Loc Qty

Loc Code

FP

81

117460

8

118077

1

118612

72

FP-A

24

110915

14

119307

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75348

75348

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

192.0000

8

8

NAS1611-013

O-RING

**

11/12/21

Location

Loc Qty

Loc Code

FP

55

117291

2

117887

53

FP-A

137

116582

5

118384

32

119307

100

x8

NAS1149D0863J

Purchased

No

250

Each

230.0000

2

2

NAS1149D0863J

WASHER

**

11/12/21

Location

Loc Qty

Loc Code

ST298

230

118078

130

119307

100

x2

D2744

Manufactured

No

110

Each

63.0000

1

1

D2744

Cap

**

BE11-11-24

Location

Loc Qty

Loc Code

LG002

13

62715

1

70881

12

WA

50

71861

50

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75348

75348

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110 Each

41.0000 1 1

D2600-3-BENT

Extrusion Bent

**

BB 11/11/22

Location

Loc Qty

Loc Code

LG

41

66875

8

73253

3

75021

10

75022

10

75023

10

D2743

Manufactured No

160 Each

201.0000 8 8

D2743

Crossbolt Spacer

**

*BE 11/12/04
B 76141 *B*

Location

Loc Qty

Loc Code

LG

143

71839

79

73403

64

LG001

58

67766

4

68251

54

D2739

Manufactured No

160 Each

9.0000 1 1

D2739

350 I Beam

**

BB 11/11/20

Location

Loc Qty

Loc Code

LG

9

72155

2

72156

3

72157

4

76866

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries